

# Work Order ID 54752



December 21, 2009 9:02:10 AM

Page 1

Item ID: D3575-2

Accept



Setup Start



Revision ID:

Item Name: Cabin Floor Protector

Stop



Start Date: 12/21/09 Start Qty: 4.00



Cust Item ID:

Required Date: 12/31/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:



Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3575	Rev A
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100	FLOW WATER JET	0.00
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Waterjet

Memo

0.00

1-Cut as per Dwg D3575     Dwg Rev: A     Prog Rev: A     2-  
Deburr if necessary

BS 10-1-14



110	QC2- Inspect parts off machine FAI/FAIB	0.00
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QC

Memo

0.00

Quality Control

BS 10-1-14

120	QC8- Inspect parts - second check	0.00
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QC

Memo

0.00

Quality Control

→ 10-1-14



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 54752**

December 21, 2009 9:02:12 AM



Page 2

Item ID: D3575-2

Accept



Setup Start



Revision ID:

Item Name: Cabin Floor Protector

Stop



Start Date: 12/21/09 Start Qty: 4.00



Cust Item ID:

Required Date: 12/31/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130

Operation  
Description

Small Fab

Small Fab

Small Fab

Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

0.00

*SAD*  
*10-01-15*

4

0.00

0.00

*>>S101015*

XG

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150



Packaging

Packaging

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

Memo

*PPP*

*54748*

0.00

0.00

*R14-11-05 C*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 54752**

December 21, 2009 9:02:17 AM



Page 3

Item ID: D3575-2

Accept



Setup Start



Revision ID:

Item Name: Cabin Floor Protector

Stop



Start Date: 12/21/09 Start Qty: 4.00



Cust Item ID:

Required Date: 12/31/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date: \_\_\_\_\_

Tooling:

Date: \_\_\_\_\_

Run Start



QC:

Date: \_\_\_\_\_

SPC (Y/N):

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
Description

160



QC21- Final Inspection - Work Order Release

QC

Quality Control

Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

0.00

10/01/18 AF  
MF  
10-1-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

December 21, 2009 9:02:10 AM

Page 1

Work Order ID: 54752



Parent Item: D3575-2



Parent Item Name: Cabin Floor Protector

Start Date: 12/21/09

Required Date: 12/31/09

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.I25-F60029-04		Purchased	No			100	sf	1,989.831	44.9095			

GE PLASTICS LEXAN SHEET

## Warehouse      Loc Qty      Loc Code

### Location

#### Main Warehouse

MAT	1989.831798	
103106	1.6765	
105330	47.8767	
109455	40.5717	
111710	329.893632	
112585	1569.81327	112585

B 10-1-14

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	54752
Description: Cabin Floor Protector	Part Number:	D3575-2
Inspection Dwg: D3575 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

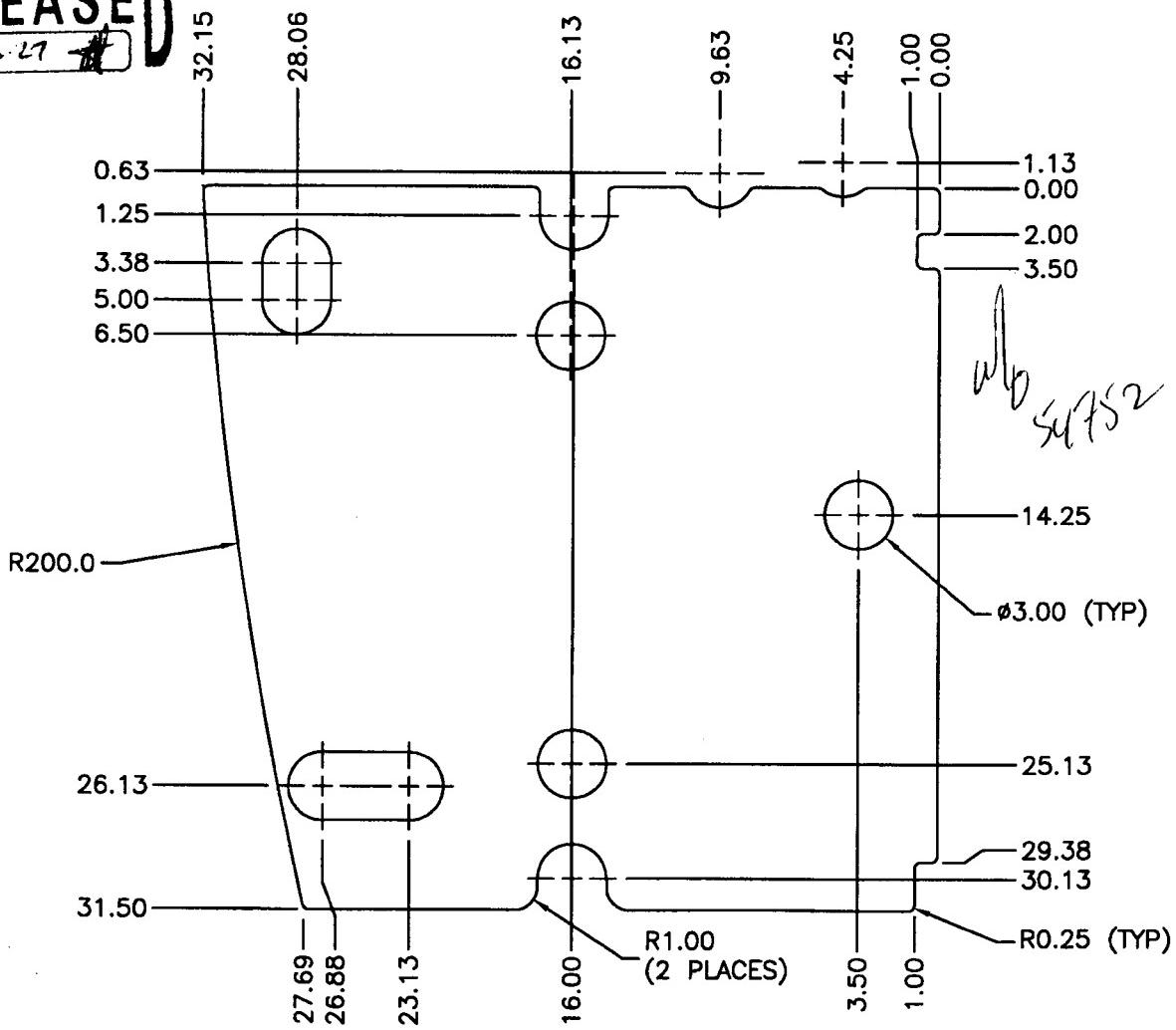
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.005	X			
1.00	+/-0.030	1.00	X			
3.50	+/-0.030	3.50	X			
16.00	+/-0.030	16.00	X			
23.13	+/-0.030	23.13	X			
26.88	+/-0.030	26.88	X			
27.69	+/-0.030	27.69	X			
4.25	+/-0.030	4.25	X			
9.63	+/-0.030	9.63	X			
16.13	+/-0.030	16.13	X			
28.06	+/-0.030	28.06	X			
32.15	+/-0.030	32.15	X			
2.00	+/-0.030	2.00	X			
3.50	+/-0.030	3.50	X			
14.25	+/-0.030	14.25	X			
25.13	+/-0.030	25.13	X			
29.38	+/-0.030	29.38	X			
30.13	+/-0.030	30.13	X			
1.25	+/-0.030	1.25	X			
3.38	+/-0.030	3.38	X			
5.00	+/-0.030	5.00	X			
6.50	+/-0.030	6.50	X			
26.13	+/-0.030	26.13	X			
31.50	+/-0.030	31.50	X			

Measured by:	HB	Audited by:	S	Prototype Approval:	N/A
Date:	10-1-14	Date:	10/6/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.29	New Issue	KJ/DD	DA

**DART**

DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>TH</i>	DRAWING NO. D3575	REV. A SHEET 1 OF 4
DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:8
A	07.06.08	NEW ISSUE	

**RELEASED**  
07.06.08

D3575-1 CABIN FLOOR PROTECTOR (SHOWN)  
D3575-2 CABIN FLOOR PROTECTOR (OPPOSITE)

NOTES:

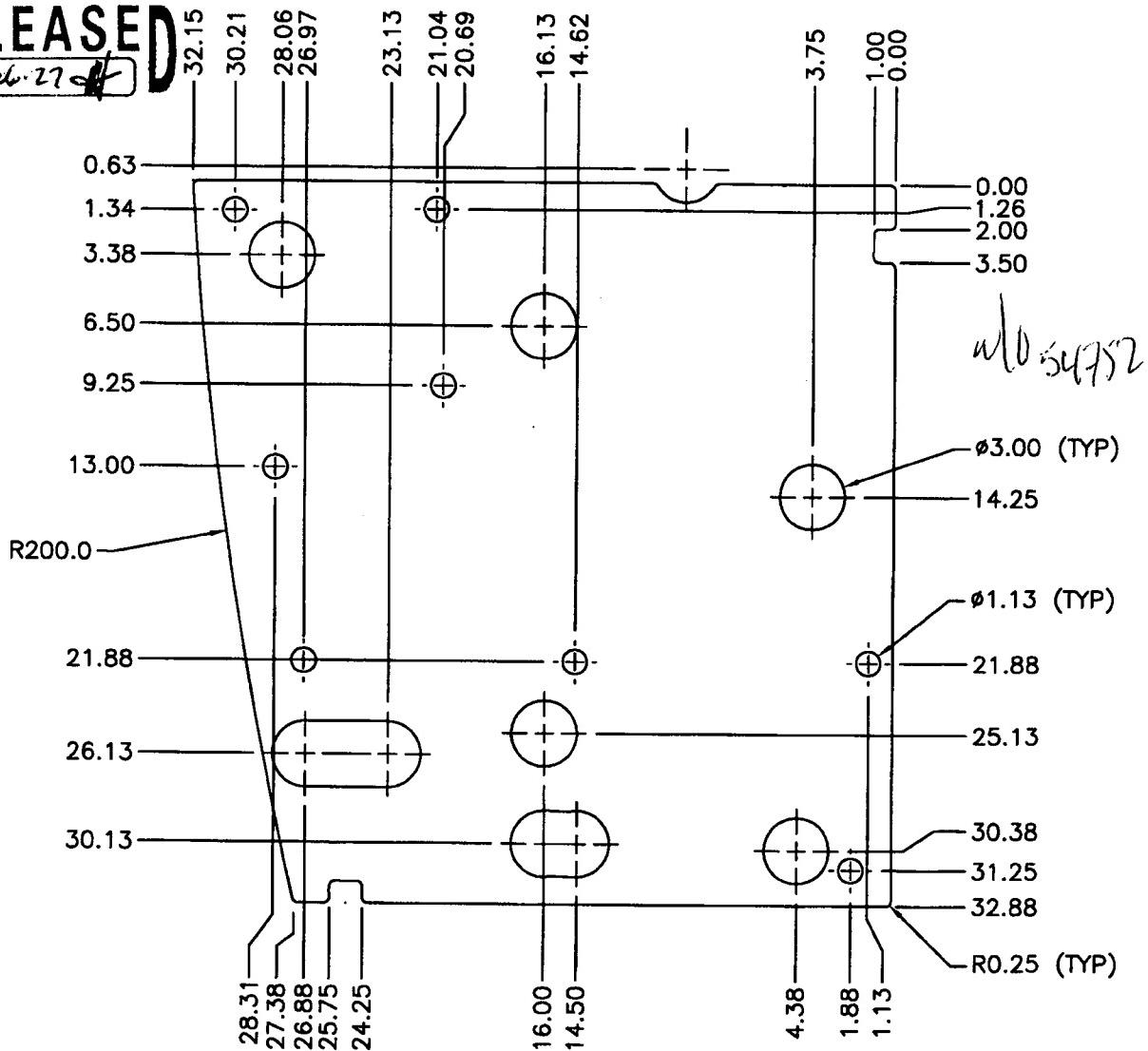
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8966



DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>CE</i>	APPROVED <i>#</i>	DRAWING NO. D3575	REV. A	SHEET 2 OF 4
DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:8	

RELEASED  
07-06-27

07-06-27 off



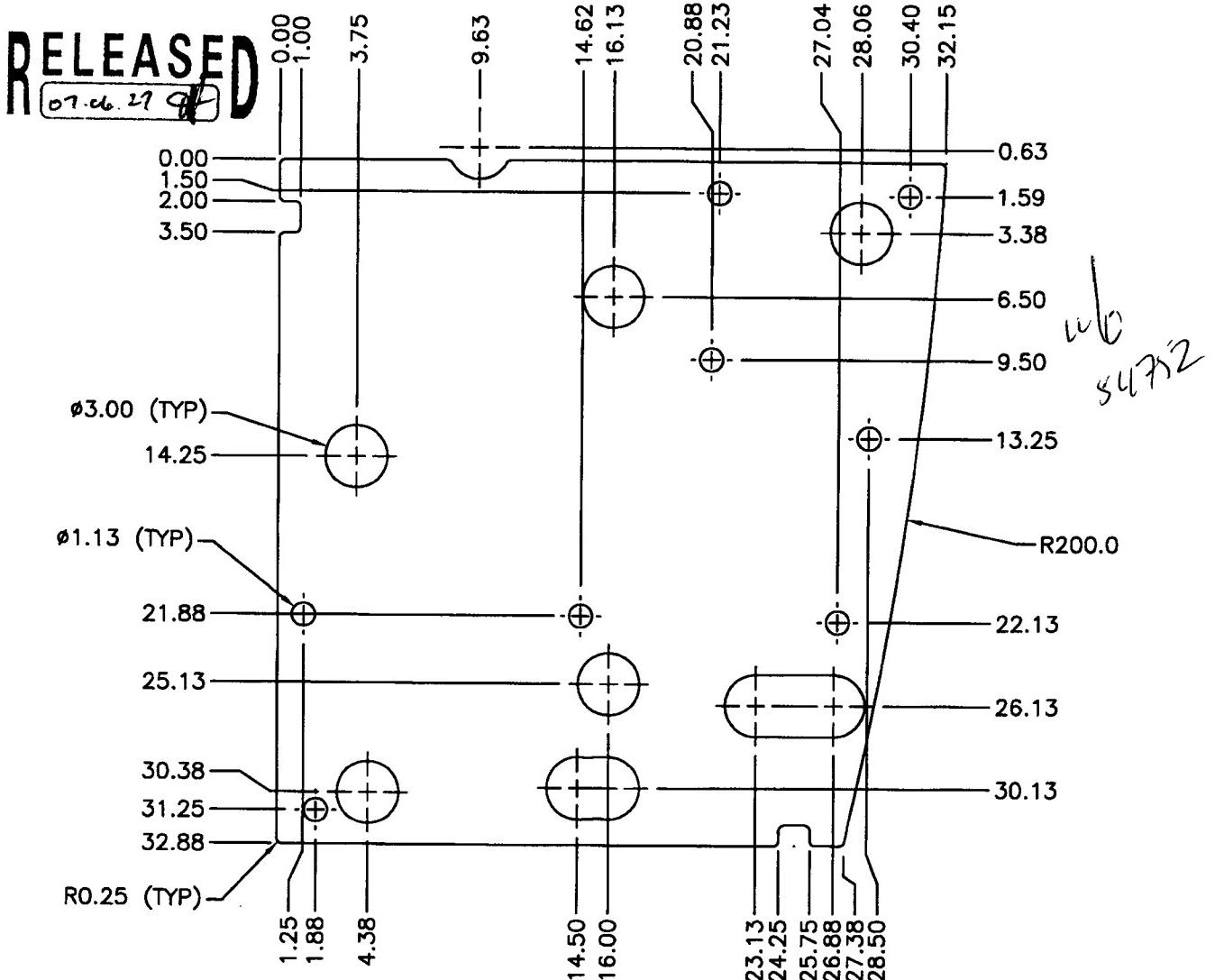
**D3575-3 CABIN FLOOR PROTECTOR**

**NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
  - 2) FINISH: NONE
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) IDENTIFY WITH DART P/N "D3575-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
  - 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
  - 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
  - 7) CHECK PER TEMPLATE DT8967

## **PART**

DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>CE</i>	APPROVED <i>AK</i>	DRAWING NO. D3575	REV. A	SHEET 3 OF 4
DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:8	



**D3575-4 CABIN FLOOR PROTECTOR**

**NOTES:**

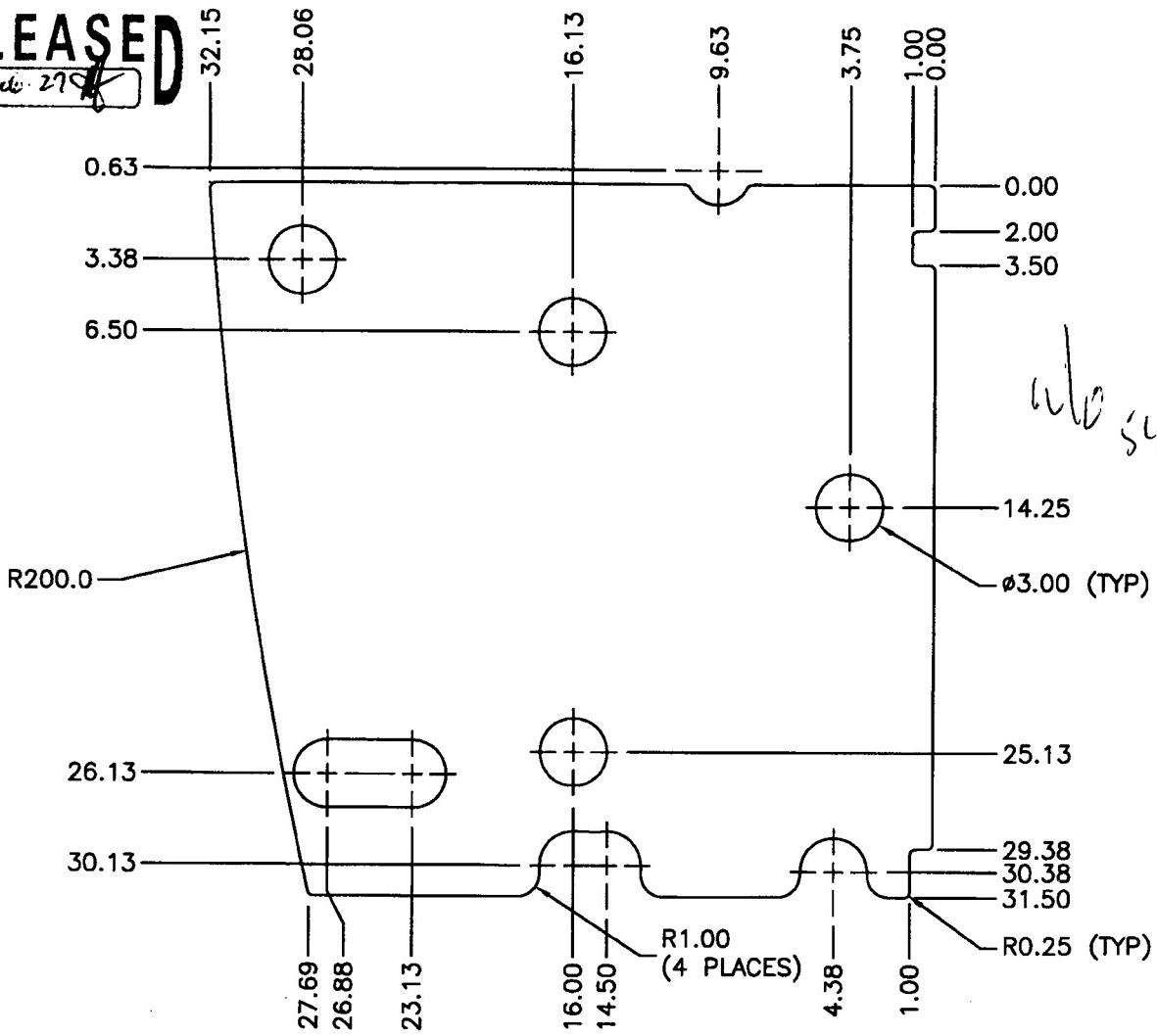
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
  - 2) FINISH: NONE
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) IDENTIFY WITH DART P/N "D3575-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
  - 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
  - 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
  - 7) CHECK PER TEMPLATE DT8968

**DART**

DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D3575	REV. A SHEET 4 OF 4
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:8

**RELEASED**

07.06.2008

**D3575-5 CABIN FLOOR PROTECTOR (SHOWN)****D3575-6 CABIN FLOOR PROTECTOR (OPPOSITE)****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-5/-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8969